

SPLIT - 1

Work Order ID 116446

116446

Page 1

Wednesday, April 16, 2014 9:14:57 AM

Item ID: D2802-2

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm

Start Date: 4/17/14

Start Qty: 100

1

Cust Item ID:

Required Date: 4/18/14

Req'd Qty: 100

1

Customer:

Reference:

Approvals:

Process Plan: *(Signature)*

Date: 4-4-15

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2802	Rev A								

100
100
BAND SAW
Bandsaw
Jeaspa Bandsaw
0.00
Memo
Cut blanks 17.800" long
0.00
5 0 *14-04-21*

110
110
HAAS 1
HAAS CNC vertical machine #1
HAAS CNC vertical machine #1
0.00
Memo
Machine as per folio FA101 Counter sink .375 dia as per dwg
0.00
14-04-21
MH 14/04/22

120
120
QC
Quality Control
QC2- Inspect parts off machine FAI/FAIB
0.00
Memo
0.00
14-04-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

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Picklist Print

Wednesday, April 16, 2014 9:15:02 AM

Page 1

Work Order ID: 116446

116446

Parent Item: D2802-2

D2802-2

Parent Item Name: Arm

Start Date: 4/17/14

Required Date: 4/18/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP: B02.03.18Re-format NG
IPP: C06.02.13Removed p/cEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X06.00 0		Purchased		No		100	f	38.9125	1.5	2			

M6061T6B0 500X06 000

6061-T6 Bar .500 x 6.00

8.4945'

214-04-21

Location

Loc Qty

Loc Code

MAT005

38.9125

122521

7.747

m126647

15.2905

m128437

15.875

8.4945'

DQA: _____ Date: _____



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DART AEROSPACE LTD		Work Order:	116446
Description: Arm		Part Number:	D2802-2
Inspection Dwg: D2802 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

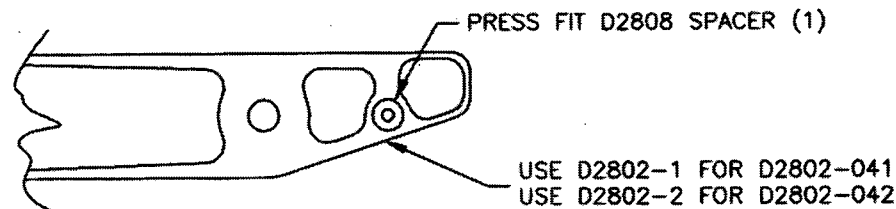
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	.503	✓		MH-04	Caliper
Ø0.191	+0.005/-0.001	.191	✓			
1.500	+/-0.010	1.500	✓			
0.100	+/-0.010	.099	✓			
9.358	+/-0.010	9.359	✓		CNC-02	Caliper
Ø0.507	+0.000/-0.001	.5065	✓		Pin gauge	-
2.033	+/-0.010	2.033	✓		MH-04	Caliper
1.000	+/-0.010	1.002	✓			
2.000	+/-0.010	2.001	✓			
1.347	+/-0.010	1.348	✓			
R0.75	+/-0.030	.75	✓		rad gauge	-
R0.0300	+/-0.010	.03	✓		rad gauge	-
R0.125	+/-0.010	.125	✓		rad gauge	-
0.500	+/-0.010	.501	✓		MH-04	Caliper
0.125	+/-0.010	.126	✓			
Ø0.507 x 0.250	+0.000/-0.001 x +/-0.010	.5065 x .251	✓			
Ø0.375 x 100°	+/-0.010 x 0.5°	.375 x 100°	✓			
0.250	+/-0.010	.250	✓			
R0.032	+/-0.010	.032	✓		rad gauge	-

Measured by: MH	Audited by: DAS 44 9-89	Prototype Approval:	N/A
Date: 14-04-22	Date: 14/04/22	Date:	N/A

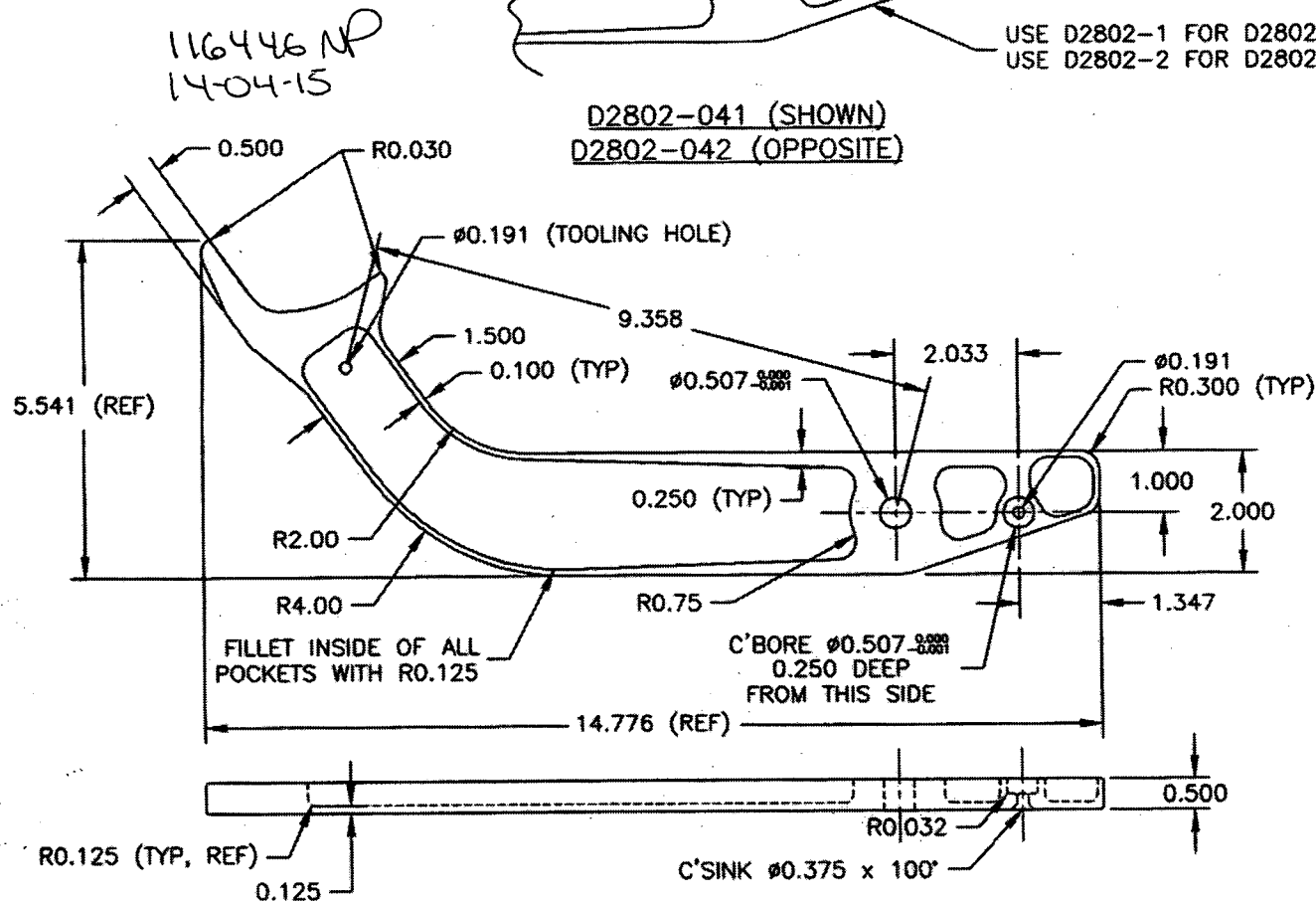
Rev	Date	Change	Revised by	Approved
A	06.08.29	New Issue	KJ/JLM	[Signature]

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>CP</i>	APPROVED <i>CP</i>	HAWKSBURY, ONTARIO, CANADA
DATE 00.11.03	TITLE ARM	REV. A
		SHEET 1 OF 1
		SCALE 1:3
A	00.11.03	NEW ISSUE

RELEASED
00-11-13 *CP*

D2802-041 (SHOWN)
D2802-042 (OPPOSITE)



D2802-1 (SHOWN)
D2802-2 (OPPOSITE)

MACHINE PER DRAWING FILE "D2802-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK (REF)
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED